

Date: Thursday, 17/04/2008 10:59:16 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	38657	Part Number :	D2573
Estimate Number :	10533	Drawing Number :	D2573 REV E
P.O. Number :		Project Number :	N/A
This Issue :	17/04/2008	Drawing Revision :	E
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	01/05/2008
Previous Run :	37923	Qty:	8 Um: Each
Written By :			
Checked & Approved By :	<u>JLD 08.4.17</u>		
Comment :	Est: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: B34876

DIP 08/05/20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 38657 Double check by: _____

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

DIP 08/05/21 / LS 04/05/23

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

DIP 08/05/24 / LS 04/05/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 38657

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/05/28

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H/RV 08/05/28

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M/107892

start: 7:40

Temp: 320°

Finish: 8:10

FX 08/05/29

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL 08-05-29 (8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

JS 08/05/30 (X8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion



W 08-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38657
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.441	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		8.000	8.000	8.003	7.997		
F	0.490	0.510		.500	.500	.510	0.5075		
G	0.257	0.262		0.259	0.259	.258	.258		
H	0.375	0.380		0.378	0.378	.377	.377		
I	0.490	0.510		.502	.505	.505	.505		
J	1.174	1.184		1.179	1.180	1.179	1.179		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.180	1.179	1.179		
M	1.365	1.375		1.370	1.368	1.368	1.370		
N	2.495	2.505		2.500	2.498	2.500	2.500		
O	4.119	4.129		4.124	4.121	4.124	4.124		
P	0.115	0.135		0.125	0.124	.125	.121		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		0.2475	0.248	.250	.249		
S	0.115	0.135		.124	.120	.120	.121		
T	0.178	0.198		0.188	0.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.228	3.230		
V	0.230	0.250		.236	.235	.238	.235		
W	0.115	0.135		.125	.123	.125	.122		
X	0.308	0.313		.309	.310	.310	0.310		
Y	0.760	0.765		.760	.760	.760	0.760		
Z	0.352	0.372		.367	.367	.365	0.365		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		.625	.625	.626	0.633		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.511	1.511	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.250	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.002	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	0.033		
Accept/Reject									

Measured by: <u>DT</u>
Date: <u>08/05/21</u>

Audited by: <u>SA</u>
Date: <u>08/05/28</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	38657
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.748	1.750	1.750	1.748		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.751	1.750	1.749		
E	7.990	8.010		7.998	7.999	7.998	7.998		
F	0.490	0.510		0.506	0.508	0.498	0.504		
G	0.257	0.262		.258	.258	.258	0.259		
H	0.375	0.380		.377	.377	.377	0.378		
I	0.490	0.510		.498	0.498	0.499	0.498		
J	1.174	1.184		1.179	1.180	1.180	1.179		
K	0.558	0.578		.568	0.567	0.564	0.564		
L	1.174	1.184		1.179	1.180	1.180	1.179		
M	1.365	1.375		1.369	1.368	1.370	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.124	4.125	4.125		
P	0.115	0.135		.123	.122	.124	0.124		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.247	.247	.247	0.247		
S	0.115	0.135		.122	0.121	0.121	0.120		
T	0.178	0.198		.188	.188	.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.235	0.232	0.232	0.231		
W	0.115	0.135		.104	0.125	0.123	0.125		
X	0.308	0.313		0.310	0.309	0.309	0.309		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.366	0.364	0.364	0.364		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		0.630	0.628	0.630	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.257	.240		
AE	1.500	1.520		1.513	1.545	1.514	1.512		
AF	0.115	0.135		.135	0.130	0.130	0.130		
AG	0.240	0.280		.260	.260	.260	0.260		
AH	0.240	0.260		.245	0.2435	0.243	0.2425		
AI	2.000	2.020		2.003	2.004	2.004	2.0015		
AJ	0.023	0.043		0.033					
Accept/Reject									

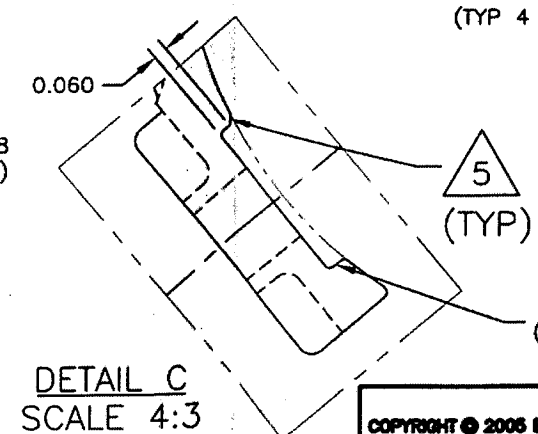
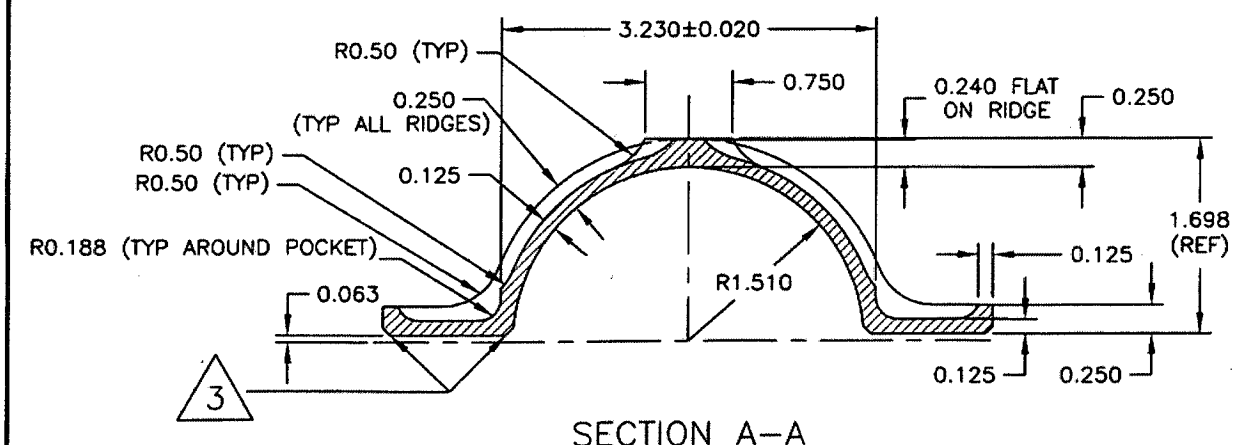
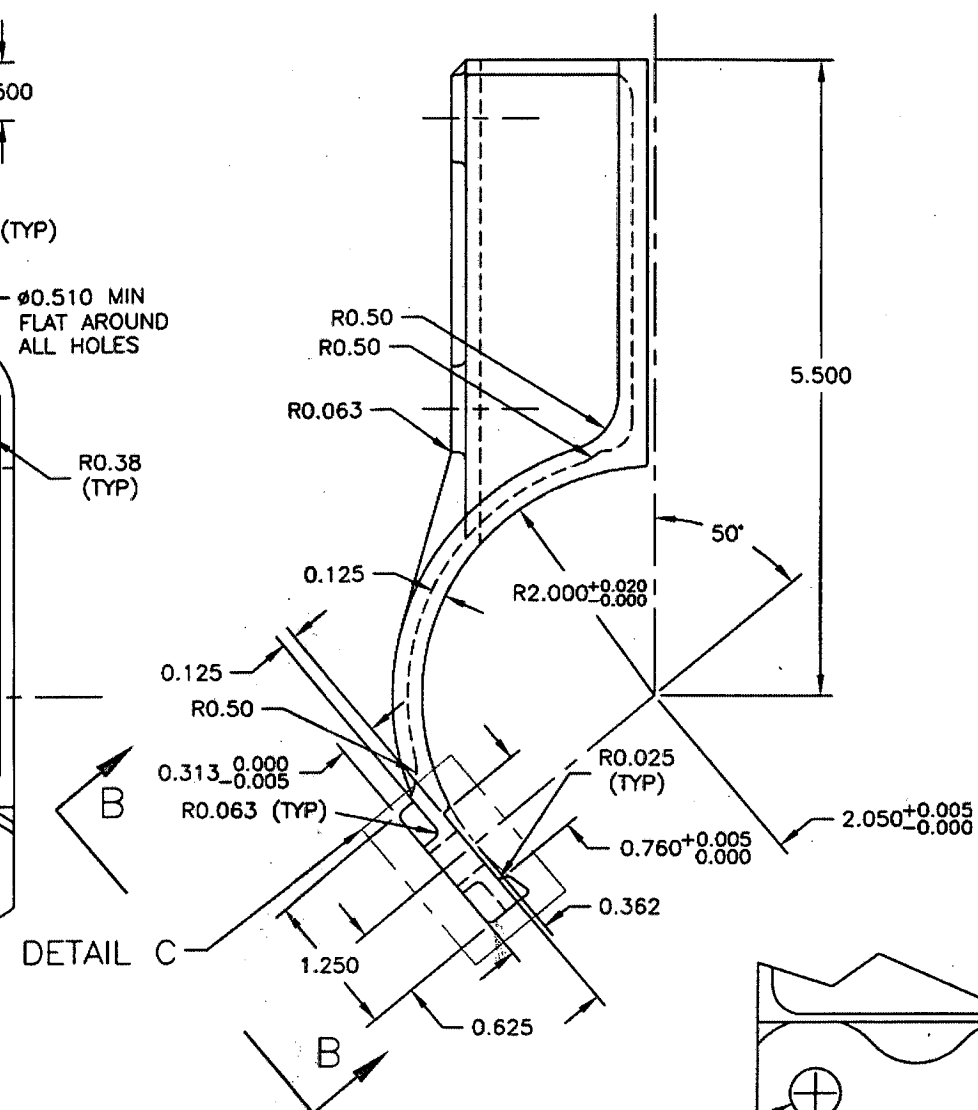
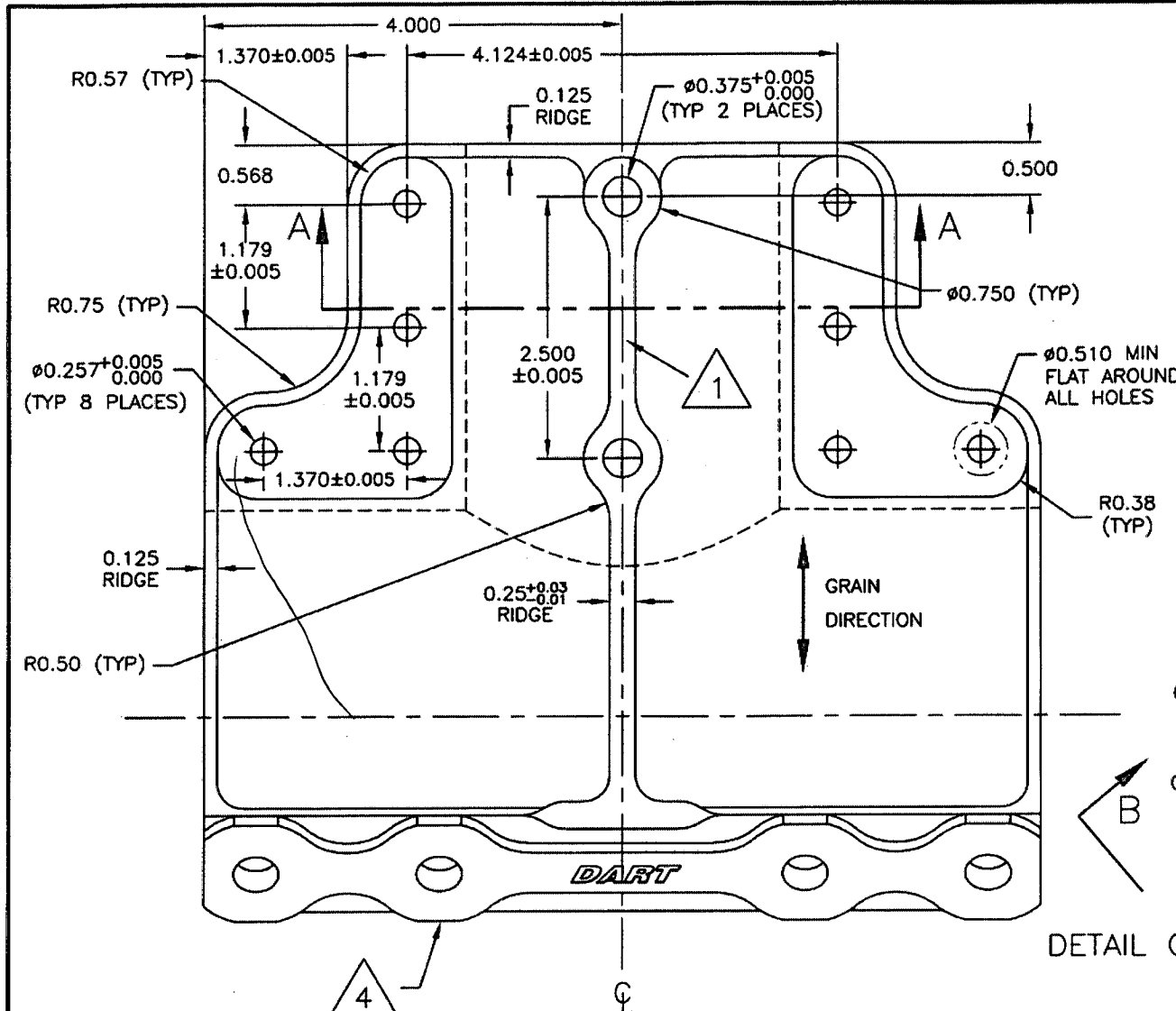
Measured by:	S.F.
Date:	08/05/23

Audited by:	[Signature]
Date:	08/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

RELEASED

05.12.06



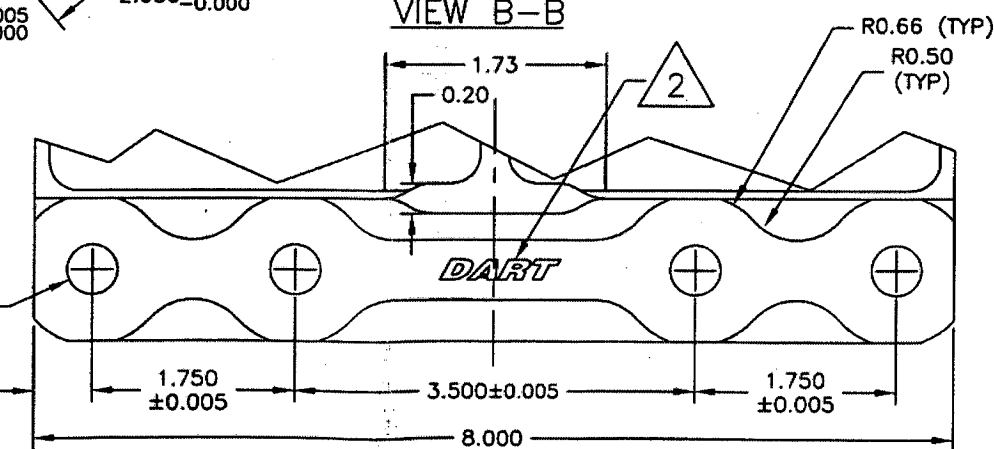
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38657

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2573
DATE 05.07.13	TITLE OUTER AFT SADDLE	REV. E SHEET 1 OF 1 SCALE 2:3

